

# Work Order ID 61245

August 11, 2010 11:48:16 AM



Page 1

Item ID: D2748

Accept



Setup Start



Revision ID:

Stop



Item Name: Clevis

Start Date: 8/11/10 Start Qty: 20.00



Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: CZ Date: 10/8/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2748	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

Flow CNC Waterjet

1-Cut as per Dwg D2748 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-  
Deburr if necessary

304 . 063

B10-8-18

(30)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-8-18

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

30 1008-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 61245

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Setup Start



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Item Name: Clevis

Start Date: 8/11/10

Start Qty: 20.00



Cust Item ID:

Required Date: 8/25/10

Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Tumble & Deburr any rough edges after tumbling ☐ Bend as per Dwg D2748  
using bending jig DT 8289

*8/20/08/24* *(30)*

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

*8.10.08/24*

*counted*  
*(x30)*

150



Packaging

Identify as per dwg & Stock Location *22*

0.00

Memo

0.00

Packaging

*10/8/24* *(30xSP)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61245**

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Item ID: D2748

Accept



Setup Start



Revision ID:

Stop



Item Name: Clevis

Start Date: 8/11/10

Start Qty: 20.00



Cust Item ID:

Required Date: 8/25/10

Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CZ10/8/24

10/08/24 [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 11, 2010 11:48:15 AM

Page 1

Work Order ID: 61245



Parent Item: D2748



Parent Item Name: Clevis

Start Date: 8/11/10

Required Date: 8/25/10

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP B 99.10.27 Now laser cutting EC  
IPP Rev:C Now on Waterjet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

0.0267

0.0145

0.305263



B 10-8-18

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT

0.026694737

111323

0

114799

0.02669474

~~111323~~

114799  
~~111323~~

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

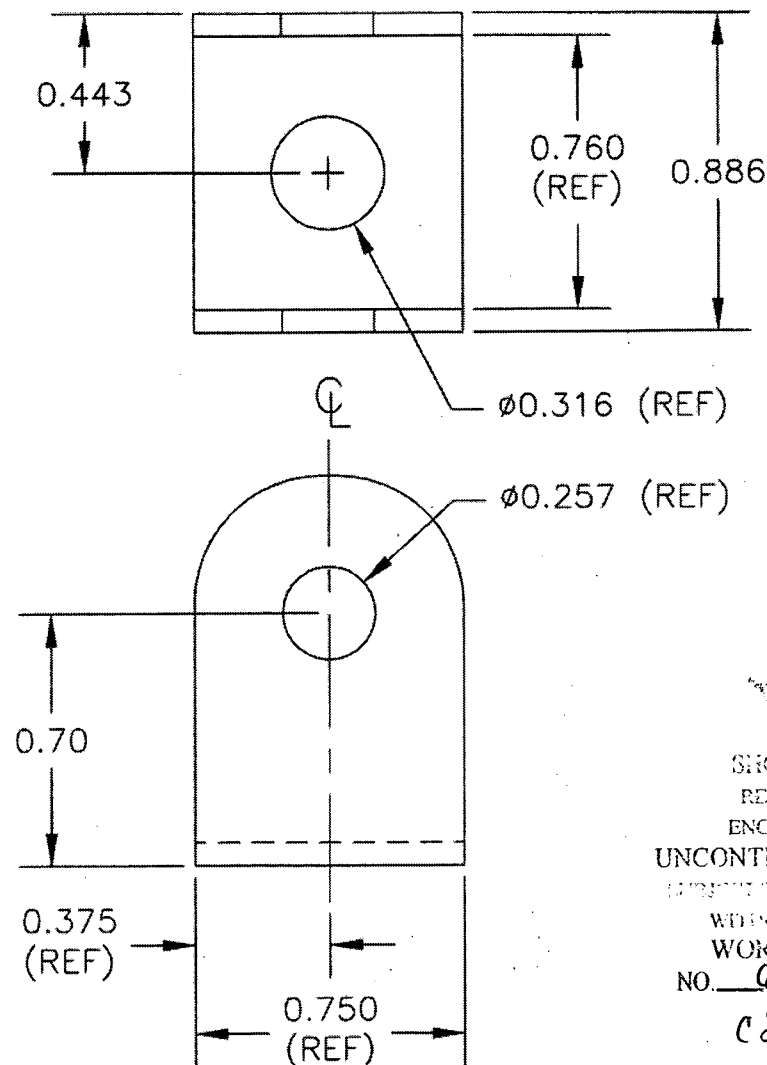






DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2748	REV. A SHEET 1 OF 2
DATE 99.09.24		TITLE CLEVIS	SCALE 2:1
A	99.09.24	NEW ISSUE	

RELEASED  
19.10.12 KE



SHOP COPY  
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SUBJECT TO AMENDMENT  
WITH REFERENCE  
WORK ORDER  
NO. 01245

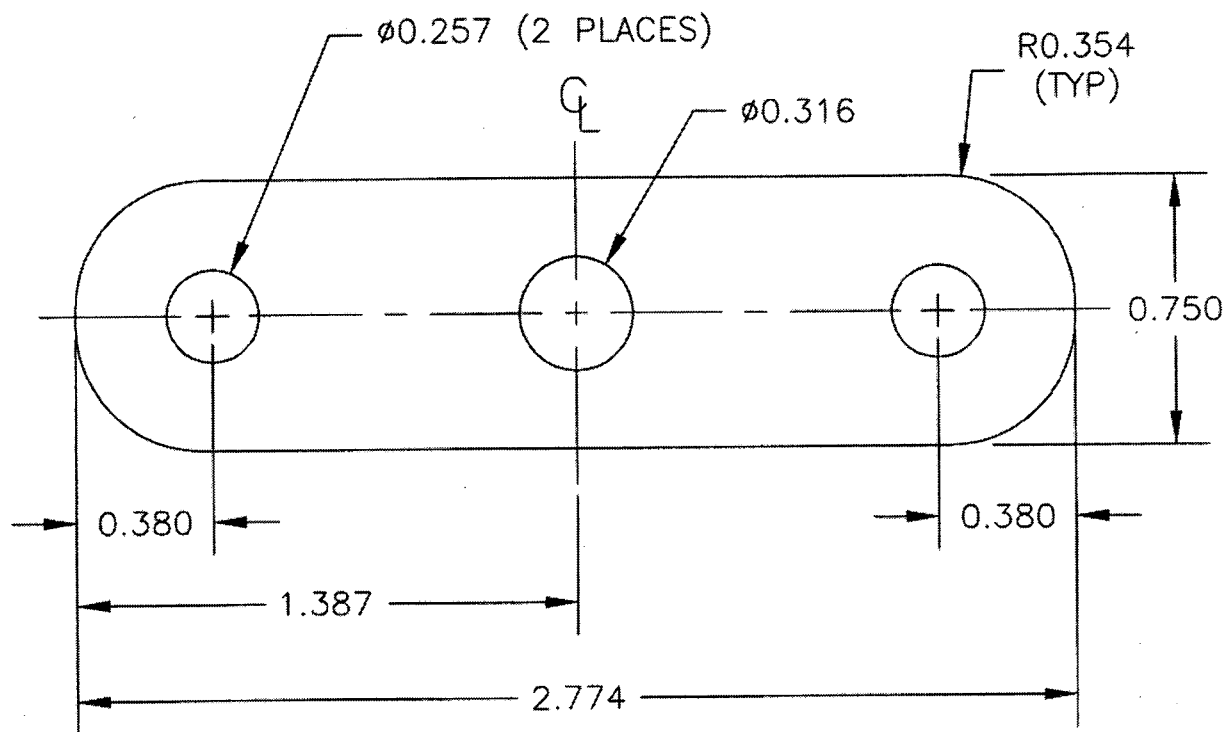
CZ 10/8/11

MATERIAL: AISI 304/316 SS 0.063 THICK  
USE 0.125 BEND RADIUS  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2748	REV. A SHEET 2 OF 2
DATE 99.09.24		TITLE CLEVIS	SCALE 2:1

RELEASED  
99.10.12 KE



D2748 FLAT PATTERN

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 61245

MATERIAL: AISI 304/316 SS 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES